

Work Order ID 52670

October 6, 2009 10:49:04 AM

Page 1

Item ID: PB67-43001-285 **GN**

Accept

Revision ID: C

Item Name: Upper Tube, Blade Positioner

Start Date: 10/06/2009 Start Qty: 2.00

Required Date: 10/08/2009 Req'd Qty: 2.00

Reference:

Approvals: Process Plan: **MP**

Date: **09-10-06**

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Setup Start

Stop

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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B67-43001

C

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1- cut to length as per dwg

2- deburr

SAD 09-10-14

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

2/8 09/10/14

120

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

1- drill hole as per dwg

2- deburr

SA 09/10/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: PB67-43001-285

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Setup Start



Revision ID: C

Stop



Item Name: Upper Tube, Blade Positioner

Start Date: 10/06/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 10/08/2009 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00

~~09/10/15~~

(2)

0



QC

Memo

0.00

09/10/20

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

mo 09/10/16

02



HandFinish

Memo

0.00

Hand Finishing

150

Green Sandtex(Ref:4.3.5.8) per QSI005 4.3

0.00

M18144

=> 94 09/10/20

(12)

9



Powdercoat

Memo

0.00

Powder Coating

START TIME: 7:45am
OVEN TEMPERATURE: 320°C
FINISH TIME: 8:15am

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	QC3- Inspect Part Finish	0.00	BR 09-10-20			2			
QC Quality Control	Memo	0.00							
170 	Identify as per dwg & Stock Location: <u>LCMS</u>	0.00	H 09.10.20			2			
Packaging Packaging	Memo	0.00							
180 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

09/10/20

MF
09-10-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 52670

Parent Item: PB67-43001-285RevB1

Parent Item Name: Upper Tube, Blade Positioner

Start Date: 10/06/2009

Required Date: 10/08/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6T1.500W.125		Purchased	No			100	f	24.7000	10.5263			
6061T6 RD TUBE 1.50 X .125W												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	24.7	
106747	5	
108626	5	
109025	7.2	
110680	7.5	

SAD 09-10-14

10,5263

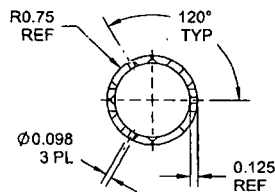
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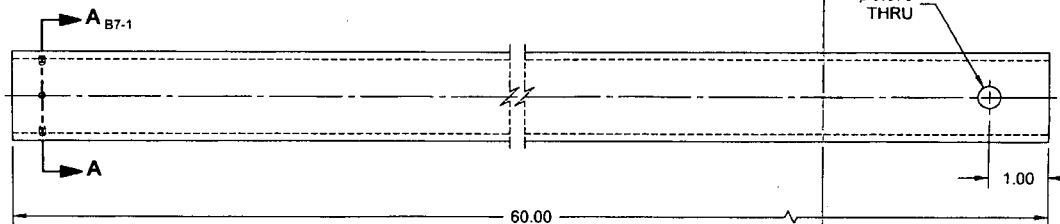
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SECTION A-A C5-1



B67-43001-285 UPPER TUBE, BLADE POSITIONER

#52670

RELEASED
2009-09-24
MP

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING
PER WW-T-700/6 OR AMS4080 OR AMS 4082 OR
AMS-QQ-A-200/8 OR AMS-QQ-A-225/8
REF. DART SPEC. M6061T6T1.500W.125
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 3.16 lbs

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 37 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.02.27
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. C	
DRAWN	h			
CHECKED	115	DRAWING NO.	SHEET 1 OF 1	
MFG. APPR.	115	B67-43001-285	SCALE	
APPROVED	MP	TITLE	SCALE	
DE APPR.	N/A	UPPER TUBE, BLADE POSITIONER	NTS	
DATE	09.02.27	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT IT		

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